

Date: Thursday, 12/20/2007 3:17:28 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36467A02  
Estimate Number : 10147  
P.O. Number : N/A  
This Issue : 12/20/2007 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : SMALL /MED FAB  
Previous Run : 28218A02  
Drawing Name : MIRROR BRACKET RH  
Part Number : D20132  
Drawing Number : D2013 REV C  
Project Number : N/A  
Drawing Revision : C  
Material : N/A  
Due Date : 1/15/2008 Qty: 4 Um: Each  
Written By :  
Checked & Approved By : 12/21  
Comment : Est Rev: A New Issue 05-11-01 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 2.0447 f(s)/Unit Total : 8.1787 f(s)  
Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing  
(M304TR0.750W.049)  
Batch: M106015

FF 08-01-10  
10-01-08 (4)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per template D2013-T1and Dwg D2013

FF 08-01-10  
10-01-08 (4)

2-Flatten ends of D2013-2 tube as per Dwg D2013 using DT8545

FF 08-01-14  
14-01-08 (4)

3-Bend (1) tube as per Dwg D2013 using Jig DT8201 identify as D2013-2.

FF 08-01-15  
08-01-14 (4)

4-Deburr as required

FF 08-01-14  
14-01-08 (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/15 (4)

4.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/16 (4)

Job Completion



Packaging

241A

8/1/15 SD (4)

08-01-16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

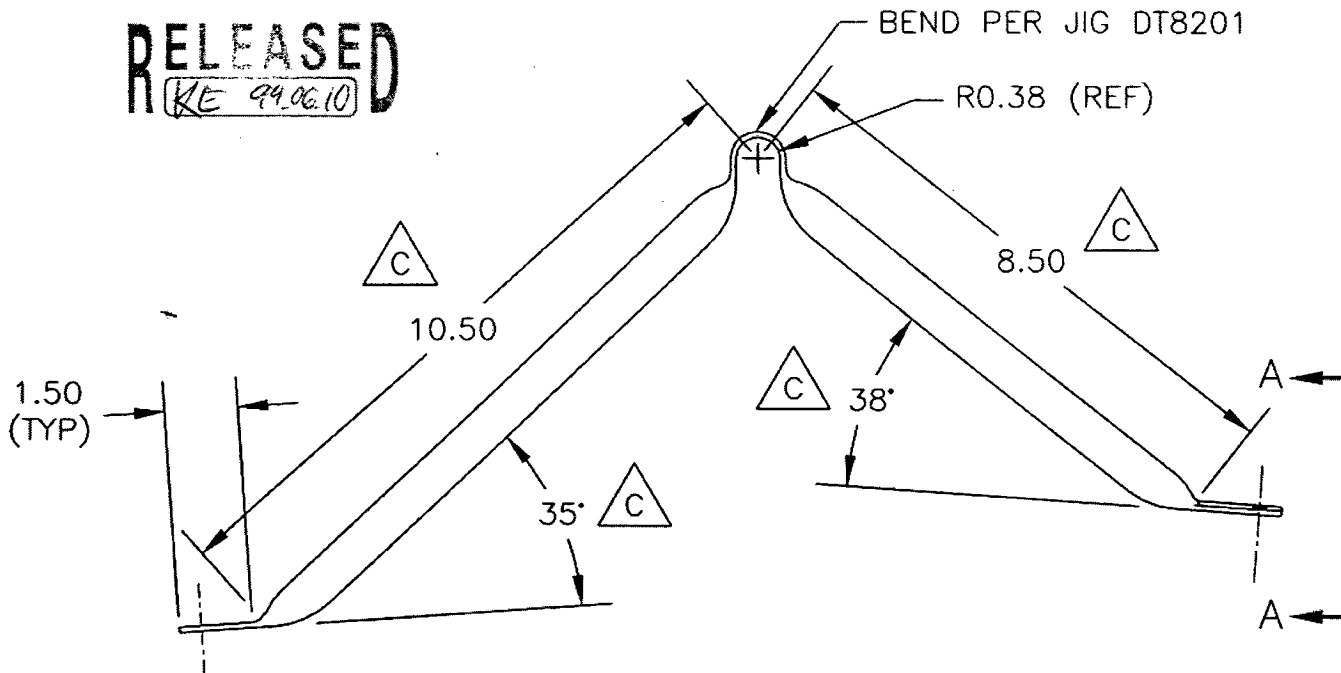
NOTE: Date & initial all entries

RELEASED  
KE 94.06.10

**DART**

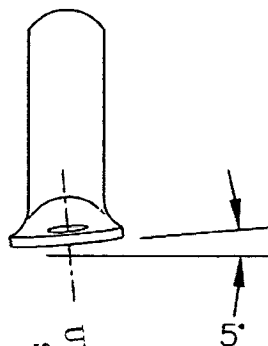


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
JB	RF	
CHECKED KE	APPROVED RF	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	REV. C SHEET 1 OF 3
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS



D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)

DRILL  $\varnothing 0.257$  (TYP)  
0.400 (TYP)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

NEW A-A  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

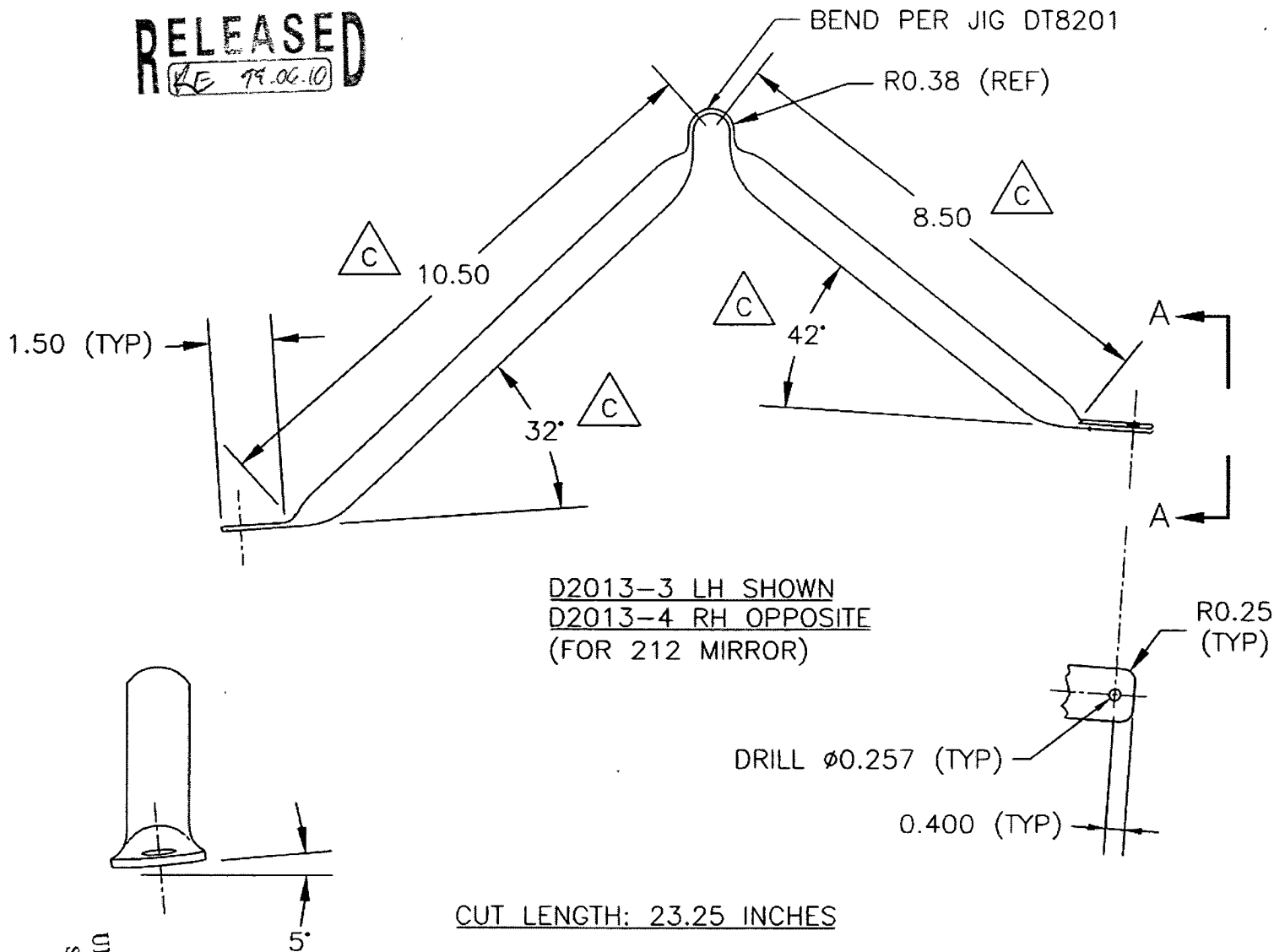
Sheet 1 of 3

RELEASED  
RE 79.06.10

**DART**



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	[Signature]	DRAWING NO. D2013
DATE	99.06.07	TITLE	MIRROR BRACKET	REV. C SHEET 2 OF 3
				SCALE NTS



MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

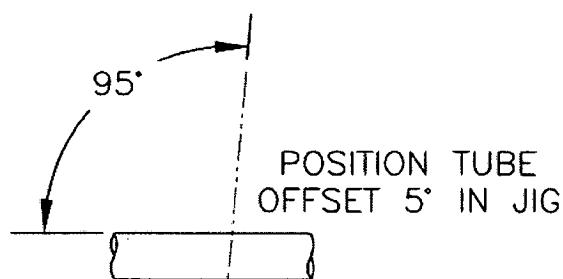
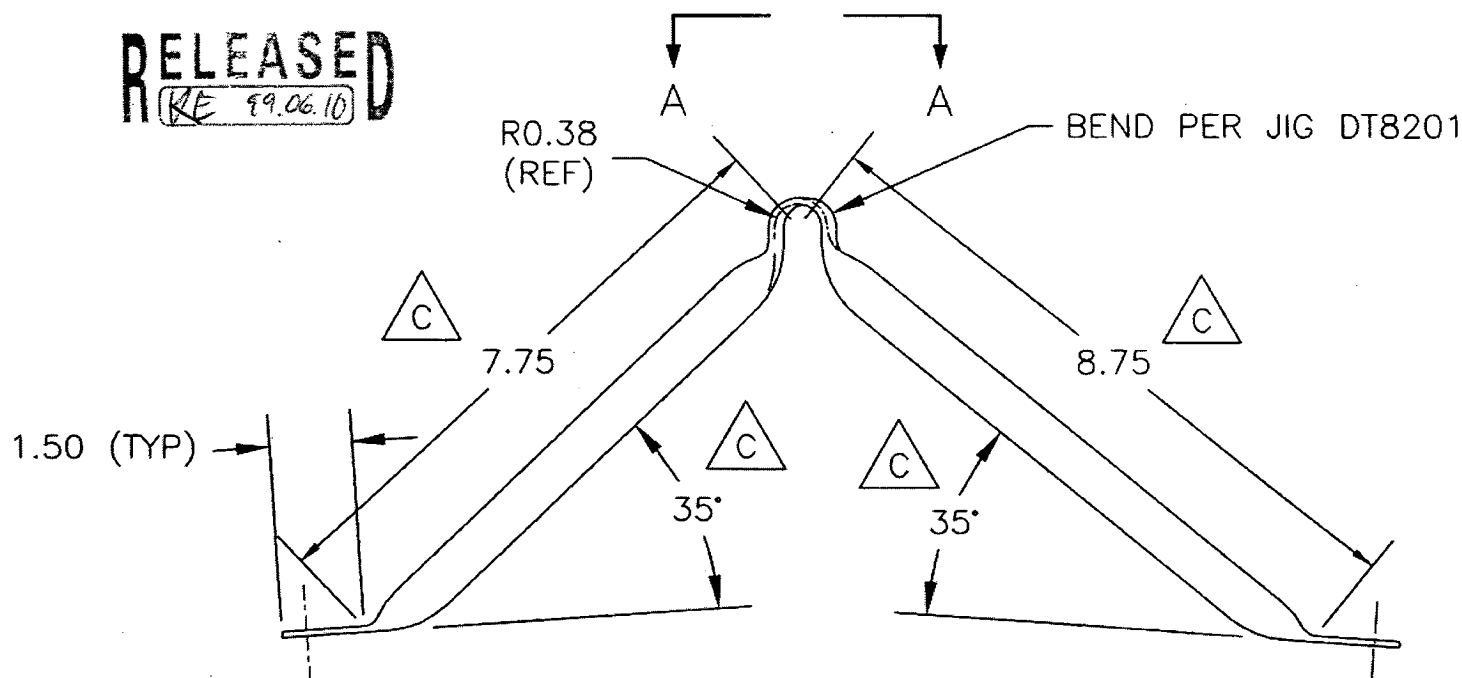
WORK ORDER  
NO 36467402

RELEASED  
(KE 99.06.10)

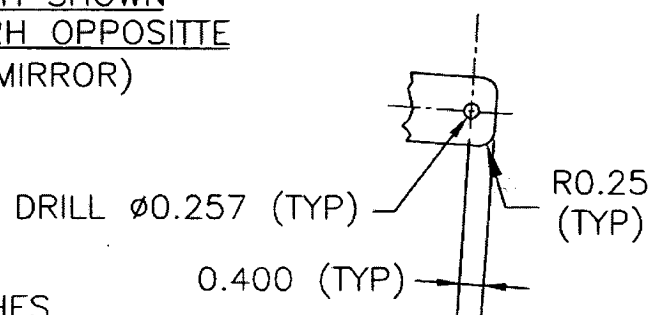
**DART**

REPRODUCED

DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.06.07	TITLE	MIRROR BRACKET	
		DRAWING NO.	D2013	
		REV. C	SHEET 3 OF 3	
		SCALE	NTS	



D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE